



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2572
Job Sheet 170025



Part No: D2572

Job Qty: 6 ea

Part Name: Saddle, Fwd, In



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/8/18

Job Tracking No:

Due Date: 1/18/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	1/17/18	1/17/18	0.00	0.00	Start Up Machining		SBL 18/01/30
100	CNC Vertical Machining	6 pcs	1/17/18	1/17/18	0.62	9.68	HAAS 1		SBL 18/01/30
110	Mill Conv	6 pcs	1/17/18	1/17/18	0.00	1.00	Mill Conv 1		FK 18-2-1
120	QC	6 pcs	1/17/18	1/17/18	0.00	0.00	QC2		FK 18-2-1
130	QC	6 pcs	1/17/18	1/17/18	0.00	0.00	QC8		mmL 18/02/02
140	HandFinish	6 pcs	1/17/18	1/17/18	0.00	0.25	HandFinish1		18-01-67
150	Powdercoat	6 pcs	1/18/18	1/18/18	0.00	0.23	Powdercoat1		BK 18-02-8
160	QC	6 pcs	1/18/18	1/18/18	0.00	0.00	QC3		11 FEB 09 2018
170	Packaging	6 pcs	1/18/18	1/18/18	0.00	0.00	Packaging3		11 FEB 12 2018
180	QC21-SA	6 Ea	1/18/18	1/18/18	0.00	0.00	QC21		11 FEB 12 2018

Part Op 100 - Program Batch No. Double check by: 1-Machine Step No 1 per Folio FA051 and inspect per

Descriptions: attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and insp

110 - Machine keyway as per dwg D2571 & D2572

150 - START TIME: 105 FINISH TIME: 1:35

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-005	6	33	0	0

F 164405 → 5036731

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Inboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Fwd Inboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Fwd Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Fwd Inboard	7.990Inches + 0.020 - 0.000	8.010 7.990		
6	Saddle, Fwd Inboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
7	Saddle, Fwd Inboard	0.257Inches	0.262		

			+ 0.005	0.257
			- 0.000	
8	Saddle, Fwd Inboard	0.375Inches	+ 0.005	0.380
			- 0.000	0.375
9	Saddle, Fwd Inboard	0.490Inches	+ 0.020	0.510
			- 0.000	0.490
10	Saddle, Fwd Inboard	1.174Inches	+ 0.010	1.184
			- 0.000	1.174
11	Saddle, Fwd Inboard	0.558Inches	+ 0.020	0.578
			- 0.000	0.558
12	Saddle, Fwd Inboard	1.174Inches	+ 0.010	1.184
			- 0.000	1.174
13	Saddle, Fwd Inboard	1.490Inches	+ 0.010	1.500
			- 0.000	1.490
14	Saddle, Fwd Inboard	2.495Inches	+ 0.010	2.505
			- 0.000	2.495
15	Saddle, Fwd Inboard	3.869Inches	+ 0.010	3.879
			- 0.000	3.869
16	Saddle, Fwd Inboard	0.115Inches	+ 0.020	0.135
			- 0.000	0.115
17	Saddle, Fwd Inboard	0.115Inches	+ 0.020	0.135
			- 0.000	0.115
18	Saddle, Fwd Inboard	0.240Inches	+ 0.020	0.260
			- 0.000	0.240
19	Saddle, Fwd Inboard	0.115Inches	+ 0.020	0.135
			- 0.000	0.115
20	Saddle, Fwd Inboard	0.178Inches	+ 0.020	0.198
			- 0.000	0.178
21	Saddle, Fwd Inboard	2.940Inches	+ 0.040	2.980
			- 0.000	2.940
22	Saddle, Fwd Inboard	0.230Inches	+ 0.020	0.250
			- 0.000	0.230
23	Saddle, Fwd Inboard	0.115Inches	+ 0.020	0.135
			- 0.000	0.115
24	Saddle, Fwd Inboard	0.307Inches	+ 0.005	0.312
			- 0.000	0.307
25	Saddle, Fwd Inboard	0.760Inches	+ 0.005	0.765
			- 0.000	0.760
26	Saddle, Fwd Inboard	0.352Inches	+ 0.020	0.372
			- 0.000	0.352
27	Saddle, Fwd Inboard	0.470Inches	+ 0.060	0.530
			- 0.000	0.470
28	Saddle, Fwd Inboard	0.615Inches	+ 0.020	0.635
			- 0.000	0.615
29	Saddle, Fwd Inboard	0.053Inches	+ 0.020	0.073
			- 0.000	0.053
30	Saddle, Fwd Inboard	0.240Inches	+ 0.020	0.260
			- 0.000	0.240
31	Saddle, Fwd Inboard	1.375Inches	+ 0.020	1.395
			- 0.000	1.375
32	Saddle, Fwd Inboard	0.115Inches	+ 0.020	0.135
			- 0.000	0.115
33	Saddle, Fwd Inboard	0.240Inches	+ 0.040	0.280
			- 0.000	0.240
34	Saddle, Fwd Inboard	0.240Inches	+ 0.020	0.260
			- 0.000	0.240
35	Saddle, Fwd Inboard	2.000Inches	+ 0.020	2.020
			- 0.000	2.000
36	Saddle, Fwd Inboard	0.023Inches	+ 0.020	0.043
			- 0.000	0.023

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : ☐																					

DART AEROSPACE LTD		Work Order: 170025
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.499	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.000	8.001	8.000		
F	0.490	0.510		.496	.500	.496	.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.499	.499	.505	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.568	.569	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		.496	.496	.496	.496		
N	2.495	2.505		2.498	2.498	2.498	2.499		
O	3.869	3.879		3.875	3.876	3.875	3.875		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.125	.125	.125	.125		
R	0.240	0.260		.253	.253	.252	.253		
S	0.115	0.135		.130	.126	.126	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.243	.240	.241	.242		
W	0.115	0.135		.129	.128	.130	.128		
X	0.307	0.312		.309	.310	.310	.310		
Y	0.760	0.765		.761	.761	.762	.761		
Z	0.352	0.372		.360	.360	.363	.361		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.623	.624	.626	.625		
AC	0.053	0.073		.065	.065	.065	.063		
AD	0.240	0.260		.253	.252	.252	.252		
AE	1.375	1.395		1.385	1.383	1.383	1.386		
AF	0.115	0.135		.130	.130	.130	.135		
AG	0.240	0.280		.250	.250	.250	.265		
AH	0.240	0.260		.250	.250	.249	.249		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: SBZ / FK
Date: 15/01/30 / 18-2-1

Audited by: [Signature]
Date: 18/02/07

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 170 025
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	3	4		
A	0.438	0.443		.438	.438				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.000				
F	0.490	0.510		.500	.498				
G	0.257	0.262		.258	.258				
H	0.375	0.380		.377	.375				
I	0.490	0.510		.500	.499				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.569	.569				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.498	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.875	3.874				
P	0.115	0.135		.130	.130				
Q	0.115	0.135		.125	.125				
R	0.240	0.260		.252	.252				
S	0.115	0.135		.127	.126				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		.240	.240				
W	0.115	0.135		.129	.128				
X	0.307	0.312		.310	.312				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.361	.361				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.625	.625				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.250	.250				
AE	1.375	1.395		1.385	1.385				
AF	0.115	0.135		.125	.125				
AG	0.240	0.280		.265	.265				
AH	0.240	0.260		.248	.248				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject				✓	✓				

Measured by: FK
Date: 18-2-1

Audited by: [Signature]
Date: 18/02/07

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	